ABSTRACT OF THE DISCLOSURE

This invention is aimed at providing a biaxially drawn, blow-molded PET bottle with a handle, which bottle is highly safe and easy to handle, even in the case of large-size bottles with a capacity as large as a few liters. This can be achieved by improving the insert moldability of the handle and by increasing the strength of fitting of the handle to the bottle. Such a bottle with a handle comprises a polyethylene terephthalate resin bottle and a handle, an injection-molded product made of a synthetic resin, which is fitted firmly to the bottle as an insert. This bottle has a recession that has been caved in at the rear of body and also comprises a vertical projecting wall disposed in the central part of the bottom of this recession. The handle comprises a pair of fitting beams disposed in parallel to each other in the standing position and a grip plate integrally disposed to connect between the pair of fitting beams at both the upper and lower ends thereof. Embedded ridges are disposed broadly in the direction of central axis of the preform at the positions where said embedded ridges stem from the pair of the fitting beams and extend from the base toward the front end face while expanding in width, so that the front end faces are opposed to the periphery of the preform under the condition that the handle is set inside the blow-molding tool. A part of the fitting beams and embedded ridges constitute the handle inserts that are fitted to the recession bottom on both sides of the vertical projecting wall of the bottle.

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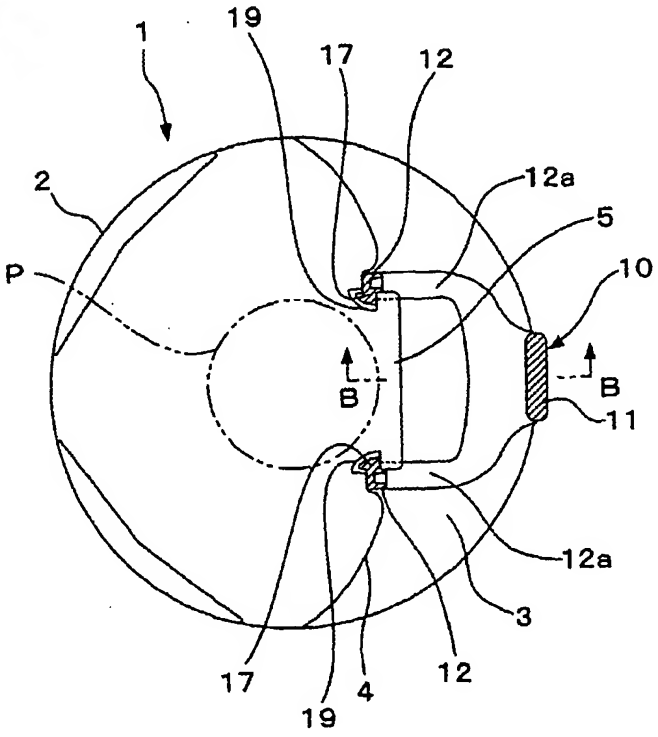
(54) Title: SYNTHETIC RESIN BOTTLE BODY WITH GRIP

(54) 発明の名称: 把手付き合成樹脂製壜体



(57) Abstract: A synthetic resin bottle body with a grip, produced by forming a bottle main body (1) made of PET by biaxial draw blow forming using, as an insert material, a grip (10) formed by injection forming. The bottle main body (1) is shaped such that a vertical projection portion (5) is provided on the center portion at a concave bottom face of a concave portion (3) provided at the rear portion of a trunk portion (2). The grip (10) is shaped such that a grip plate (11) is integrally provided between the upper and lower ends of a pair of assembled beam pieces (12) arranged parallel to each other in a raised position of the bottle body. The width of the grip portion is enlarged from the pair of assembled beams (12) as base end portions toward the tip portion. Fit projections (17) are projected toward substantially the center axis direction of a preform so that a tip face is positioned opposed to the preform outer periphery with the grip being set in a blow-forming mold. An insert portion for the concave bottom face portion near the vertical projection portion (5) of the bottle main body(1) is structured of part of the assembled beam pieces (12) and of the fit projections (17). This way, the insertion capability of the grip (10) is enhanced and fit strength between the bottle main body (1) and the grip (10) is increased.

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